

Wednesday, July 26, 2017 9:41:58 AM

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0.05

ASAP! *1646.33*

Work Order ID 164633***164633***

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Item ID: D4961-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tube Assembly
Start Date: 7/26/2017 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 7/31/2017 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.50							
Quality Control									

17/7/28

CM 7/27/17

(A)

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D4961-045

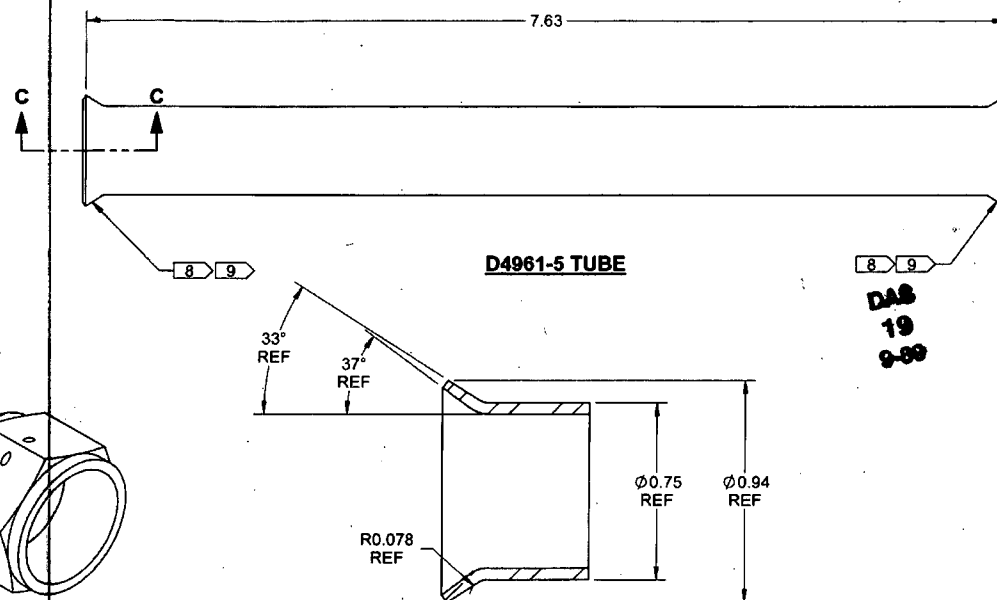
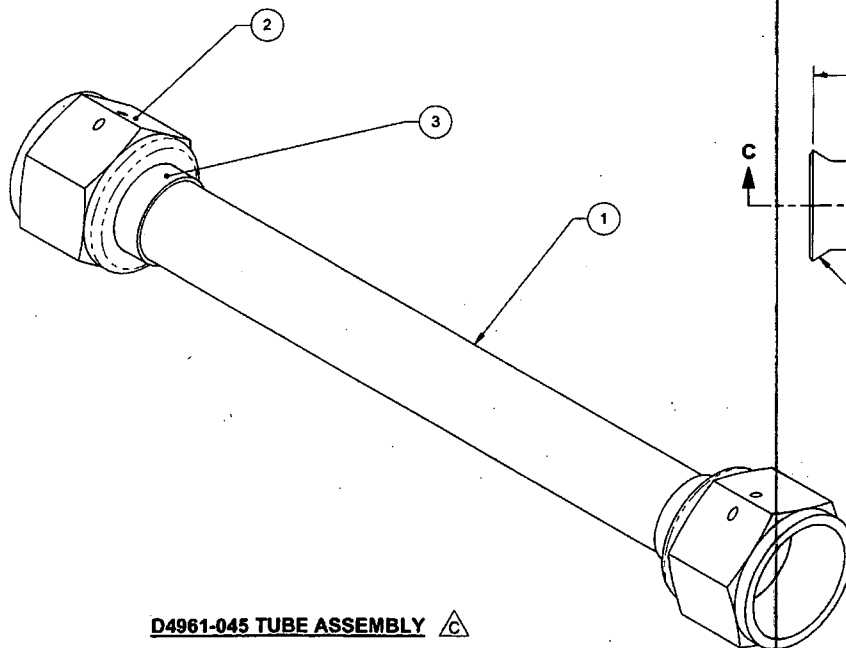
Required Date: 7/31/2017

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 16-08-05 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN818-L12J		Purchased	No			110	Each	11.0000	2	10			
AN818-I 12.I													
Nut													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				OVER007		11							
				m137820		11							
M304TR0.750W.049		Purchased	No			110	f	69.2890	0.65	3.421053			
M304TR0 750W 049													
304 RD Tube .750 x .049W													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA002		69.2889922							
				M135709		0.0000037							
				M136943		0.000158							
				M137091		0.0065145							
				M137286		9.257316							
				2 M137477		3.921				2	1.372		
				M137623		1.042							
				M137761		16.462							
				3 M138083		38.6				3	2.058		
MS20819-12J		Purchased	No			110	Each	30.0000	2	10			
MS20819-12.I													
Sleeve													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				over006		10							
				m137820		10							
				ST305		20							
				m138040		20							

ITEM	QTY 045	P/N	DESCRIPTION
	X	D4961-045	TUBE ASSEMBLY
1	1	D4961-5	TUBE
2	2	AN818-L12J	NUT
3	2	MS20819-12J	SLEEVE



DAS
19
9-00

SECTION C-C

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING, $\phi 0.750 \times 0.049$ WALL PER ASTM A213 OR ASME SA213 OR ASTM A269 (REF DART SPEC M304TR)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.59 lbs
- 8) FLARE TUBE PER MS33584
- 9) CLEAN INSIDE OF TUBE AFTER FLARING ENDS

RELEASED
2016-08-04

APPROVED

DESIGN	VS
DRAWN	CC
CHECKED	VS
MFG. APPR.	DD
APPROVED	HS
DE APPR.	DS
DATE	16.06.21

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4961** REV. C
TITLE **TUBE ASSEMBLY** SCALE NTS

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